

# Work Order ID 80423

February-21-12 9:10:05 AM

\*80423\*

Page 1

Item ID: D3639-2

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 21/02/2012 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/02/21

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3639	Rev A
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100		0.00							
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\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

2024.050

110		0.00							
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\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120		0.00							
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\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 12/02/27

W 12 02 26 (8)

W 12 02 26 (8)

(70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80423

February-21-12 9:10:05 AM

**\*80423\***

Page 2

Item ID: D3639-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 21/02/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

**\*140\***

Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3639

0.00

0.00

SB 12/02/27

(8)

150

**\*150\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 12/02/28

(8)

160

**\*160\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

M-L (8) 12/02/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February-21-12 9:10:10 AM

Page 1

Work Order ID: 80423

\*80423\*

Parent Item: D3639-2

\*D3639-2\*

Parent Item Name: Doubler

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM  
remove c'sink DD 10.04.13 verified by:EC

Verified By:EC IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	68.6000	0.239	2.012632			

\*M2024T3S 050\*

2024-T3 .050 sheet

\*\*

12 02 26

Location

Loc Qty

Loc Code

MAT022

68.6

117684

68.6

16.096

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>80423</b>
<b>Description:</b> Doubler		<b>Part Number:</b>	<b>D3639-2</b>
<b>Inspection Dwg:</b> D3639 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0.627	✓		vern	HB.02
Ø0.191	+0.005/-0.001	0.195	✓		vern	
Ø0.098	+0.004/-0.001	0.100	✓		vern	
0.69	+/-0.030	0.69	✓		vern	
1.59	+/-0.030	1.592	✓		vern	
2.49	+/-0.030	2.491	✓		vern	
3.39	+/-0.030	3.385	✓		vern	
3.990	+/-0.010	3.996	✓		vern	
4.990	+/-0.010	4.994	✓		vern	
5.19	+/-0.030	5.180	✓		vern	
6.99	+/-0.030	6.994	✓		vern	
8.64	+/-0.030	8.625	✓		vern	
0.45	+/-0.030	0.456	✓		vern	
0.710	+/-0.010	0.713	✓		vern	
2.000	+/-0.010	2.005	✓		vern	
2.75	+/-0.030	2.756	✓		vern	
3.55	+/-0.030	3.556	✓		vern	
4.00	+/-0.030	4.008	✓		vern	
2.000	+/-0.010	2.004	✓		vern	
2.590	+/-0.010	2.595	✓		vern	

<b>Measured by:</b>	<i>[Signature]</i>
<b>Date:</b>	12.02.26

<b>Audited by:</b>	<i>[Signature]</i>
<b>Date:</b>	12/02/27

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	<i>[Signature]</i>

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

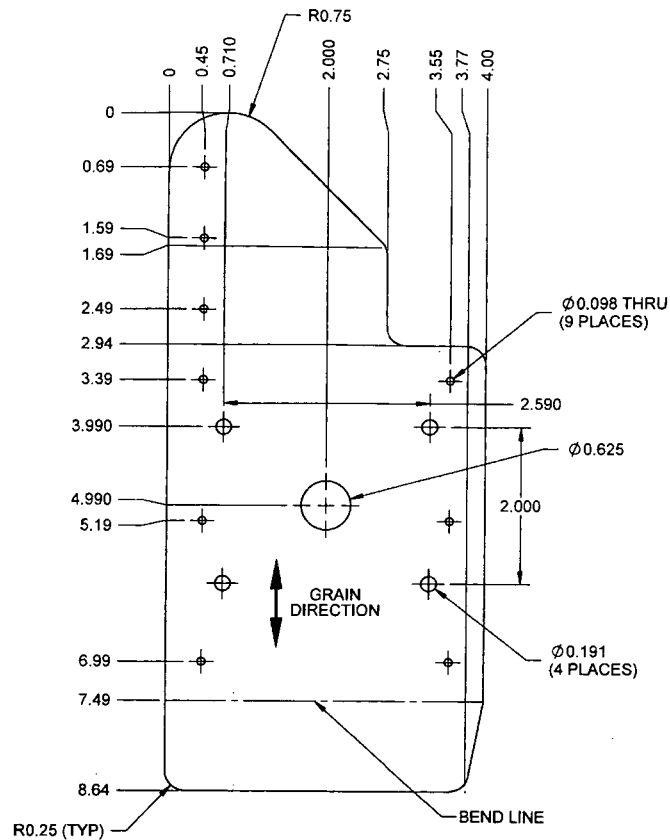
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D

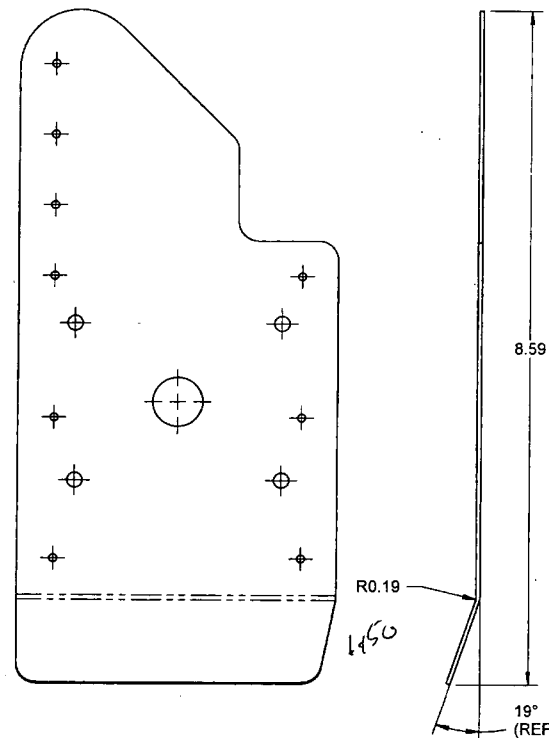
C

B

A



**D3639-1F FLAT PATTERN**  
**(D3639-2F OPPOSITE)**



**D3639-1 DOUBLER**  
**(WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE**  
**(WAS GENEVA P/N G10604-6)**



**RELEASED**  
07-07-27

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.14 lbs

NO-80423-M.C.5  
12/02/21

A	NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.		
DRAWN	LE	PORT HADLOCK, WA		
CHECKED	B	DRAWING NO.	REV. A	
MFG. APPR.	B	D3639	SHEET 1 OF 2	
APPROVED	12	TITLE	SCALE	
DE APPR.	12	DOUBLER	2:3	
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

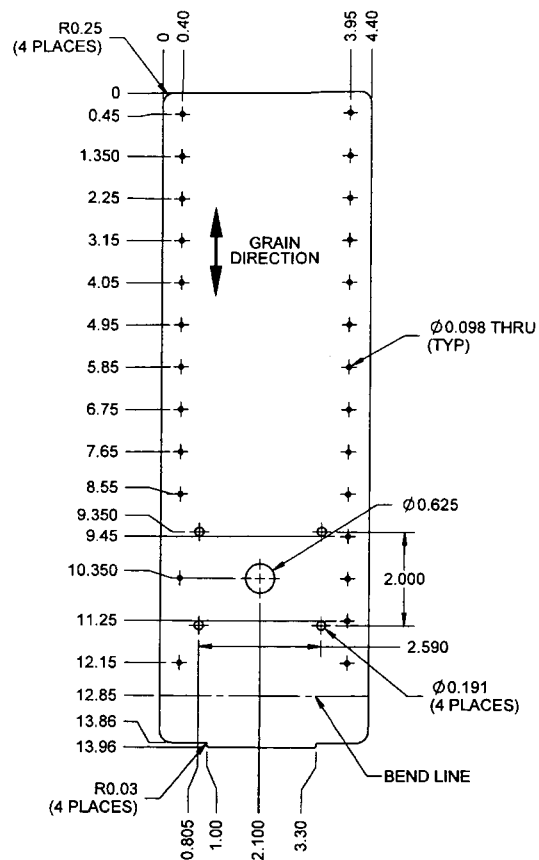
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

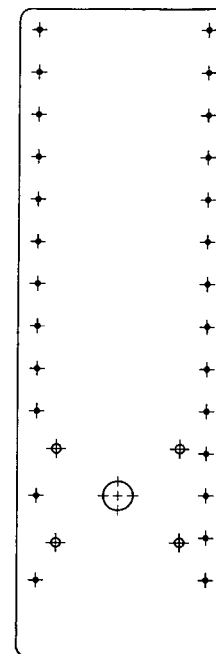
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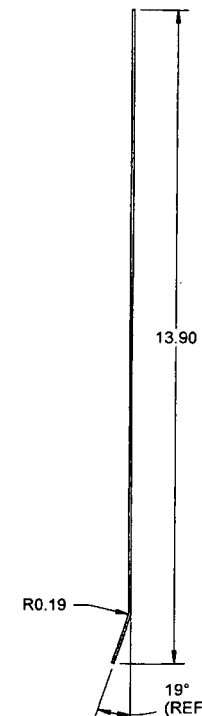
80423



**D3639-3F FLAT PATTERN  
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER  
(WAS GENEVA P/N G10604-4)  
D3639-4 OPPOSITE  
(WAS GENEVA P/N G10604-5)**



**RELEASED**  
07.09.07

- NOTES:**
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  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D3639	SHEET 2 OF 2
APPROVED	BE	TITLE	SCALE
DE APPR.	BE	DOUBLER	2:
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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